

Work Order ID 149194

July 21, 2016 3:19:56 PM

149194

Page 1

Item ID: D2571

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Saddle, Fwd, Out

Start Date: 9/20/2016 Start Qty: 10.00

10

Cust Item ID:

Required Date: 9/30/2016 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan: SMDate: 7/25/16

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2571	F								

100

100

HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

0.02

0.68

Memo

Program Batch No. B149194Double check by: MM

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets

2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets

3-Machine Step No 3 per Folio FA051 and inspect

B.A. 16/08/10

DAS
08
9-85

10 1

16-08-12

110

110

Mill Conv

Conventional Milling Machine

CONVENTIONAL MILLING MACHINE

0.00

0.33

Memo

Machine keyway as per dwg D2571 & D2572

B.A. 16/08/13

DAS
08
9-85

10 1

16-08-12

PTO

DQA: Date: JAN 3 2017



QA Closed: Date: DEC 20 2016 **WORK ORDER NON-CONFORMANCE / UPDATE**

Work Order update only ☐

Work Order: <u>149194</u> Part No. <u>D2571</u> NCR No. <u>16-6185</u>		DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☒</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☒</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☒	Small Fab ☐	Prod. Eng. Coord. ☒	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																															
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Date: <u>16-08-13</u>		Step #: <u>100</u>		QTY Effective: <u>①</u>		MRB (QSI042) Approval <u>DAS</u> <u>9</u> <u>9-89</u> <u>16-08-13</u>																																																																	
Description Work Order Deviation				Disposition																																																																			
→ Skid bore thickness is under tolerance → Thickness goes from .107" to .113" and tol. is .125" +/- .010 → An offset of .014" has to be entered in controller to achieve nominal size but operator put the offset on a different tool by error.				scrap + destroy replace <u>B147681</u> (X1)																																																																			
				Completed By <u>DA</u> <u>16/08/13</u>																																																																			
				Lead hand / Supervisor Approval Verification <u>DAS</u> <u>9</u> <u>9-89</u> <u>16-08-13</u>																																																																			
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Work Order ID 149194

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Page 2

Item ID: D2571 Accept *N900040100* Setup Start *NS1*

Revision ID: Stop *NS2*

Item Name: Saddle, Fwd, Out

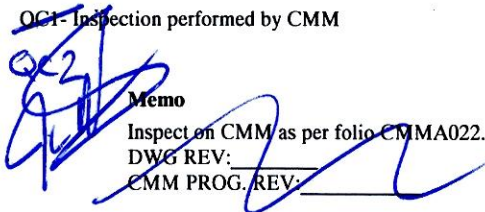
Start Date: 9/20/2016 Start Qty: 10.00 *10* Cust Item ID:

Required Date: 9/30/2016 Req'd Qty: 10.00 *10* Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC1- Inspection performed by CMM  Memo Inspect on CMM as per folio CMMMA022. DWG REV: _____ CMM PROG. REV: _____	0.00 0.02		B-A 16/08/13	DAS 08 9-89	10	1		
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.03							DAS 14 9-89
140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.03				(10)			2016/08/12 BEB

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Monday, August 22, 2016 12:39:16 PM

149194

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N900040100

Setup Start *NS1*

Stop *NS2*

10

Cust Item ID:

Start Date: 9/20/2016 **Start Qty:** 10.00

Required Date: 9/30/2016 **Req'd Qty:** 10.00

10

Customer:

Reference:

Approvals: _____ **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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151 Spray Painting per QSI005 4.2

0.00

151

0.00

SprayPaint

Memo

PRIME AS PER QSI 005

PRIME BATCH 135172

PAINT AS PER OSI 005

DRAB GREEN

BATCH 135836

161 QC14- Inspect Spray Paint

0.00

161

0.00

QC

Memo

Quality Control

Identify as per dwg & Stock Location: 

0.00

170

0.02

Packaging

Memo

Packaging

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
		OTHER :			

Work Order ID 149194

July 21, 2016 3:19:56 PM

149194

Page 4

Item ID: D2571 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Saddle, Fwd, Out
Start Date: 9/20/2016 Start Qty: 10.00 ***10*** Cust Item ID:
Required Date: 9/30/2016 Req'd Qty: 10.00 ***10*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 ¹	QC21- Final Inspection - Work Order Release	0.00					DAS 21 9-89		OCT 1 0 2016
180									OCT 1 8 2016
QC	Memo	0.17							
Quality Control							DAS 21 9-89		OCT 1 8 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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OTHER : _____																																																															

Picklist Print

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Page 1
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Work Order ID: 149194

149194

Parent Item: D2571

D2571

Parent Item Name: Saddle, Fwd, Out

Start Date: 9/20/2016

Required Date: 9/30/2016

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP: 102.10.02Re-format; Change to Dwg Rev. D & incorporated
D2572KJ

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D6101-007		Manufactured	No			100	Each	28.0000	1	10			
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D6101-007

Saddle Billet

B.n 16/08/10

Location

Loc Qty

Loc Code

MAT041

28

143818

1

→147681

13

147810

14

10.0 + 1.0

DQA: _____ Date: _____

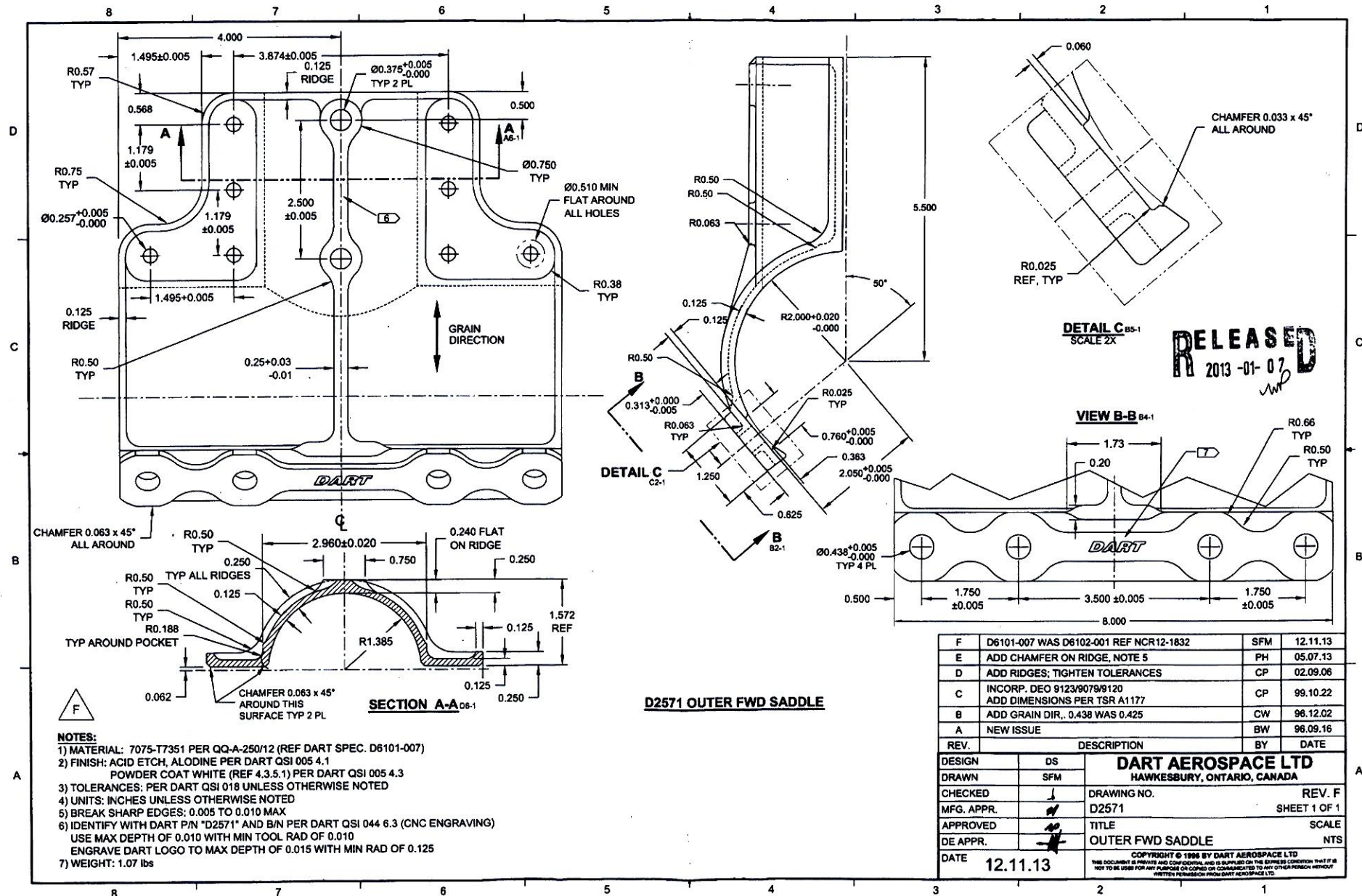


WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							



DART AEROSPACE LTD	Work Order:	149194
Description: Saddle, Fwd Outboard	Part Number:	D2571
Inspection Dwg: D2571 Rev. F		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
				SCRAP					
A	0.438	0.443		.438	.438	.438	.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		7.999	7.999	7.999	7.999		
F	0.490	0.510	.281	.502	.505	.502	.503		
G	0.257	0.262		.257	.257	.257	.257		
H	0.375	0.380		.375	.375	.375	.375		
I	0.490	0.510	.3125	.5035	.4985	.502	.502		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578	.4395	.5705	.568	.568	.5685		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		.135	.135	.135	.135		
Q	0.115	0.135		.124	.125	.125	.123		
R	0.240	0.260		.253	.253	.252	.251		
S	0.115	0.135		.118	.123	.125	.123		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.959	2.960	2.960	2.960		
V	0.230	0.250		.239	.246	.248	.239		
W	0.115	0.135		.107	.115	.115	.120		
X	0.308	0.313		.317	.312	.312	.310		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.363	.363	.363	.363		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635	.406	.629	.629	.629	.627		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.249	.256	.248	.250		
AE	1.375	1.395		1.385	1.385	1.385	1.385		
AF	0.115	0.135		.135	.135	.135	.136		
AG	0.240	0.280		.255	.245	.245	.243		
AH	0.240	0.260		.249	.252	.257	.247		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		.033	.033	.033	.033		

Accept/Reject

Measured by:	16-0811 / D.2
Date:	16/08/13

Audited by:	DAS
Date:	16/08/22

Rev	Date	Change	Revised by	Approved
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	

DART AEROSPACE LTD	Work Order:	
Description: Saddle, Fwd Outboard	Part Number:	D2571
Inspection Dwg: D2571 Rev. F		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	15	26	27	48		
A	0.438	0.443		.438	.438	.438	.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		7.999	7.999	7.999	7.999		
F	0.490	0.510	294	0.500	0.501	0.501	0.500		
G	0.257	0.262		.257	.257	.257	.257		
H	0.375	0.380		.375	.375	.375	.375		
I	0.490	0.510	3125	.490	0.500	0.502	0.502		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578	4395	.568	0.567	0.567	0.568		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		.135	.135	.135	.135		
Q	0.115	0.135		.124	.124	.125	0.123		
R	0.240	0.260		.252	.252	.250	0.249		
S	0.115	0.135		.128	0.128	0.128	0.128		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		.240	0.243	0.243	0.242		
W	0.115	0.135		.125	0.121	0.121	0.120		
X	0.308	0.313		.310	0.310	0.310	0.310		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		0.363	0.363	0.363	0.363		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635	406	0.627	0.627	0.627	0.627		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.251	0.252	0.251	0.251		
AE	1.375	1.395		1.385	1.385	1.385	1.385		
AF	0.115	0.135		.135	.135	.135	.135		
AG	0.240	0.280		.245	.245	.245	.245		
AH	0.240	0.260		.245	0.250	0.250	0.250		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		.033	.033	.033	.033		

Accept/Reject

Measured by: <i>[Signature]</i>	Audited by: <i>[Signature]</i>
Date: 14-08-12	Date: 16/08/12

Rev	Date	Change	Revised by	Approved
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	

DART AEROSPACE LTD		Work Order:	
Description: Saddle, Fwd Outboard		Part Number:	D2571
Inspection Dwg: D2571 Rev. F		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	19	710	11	4		
A	0.438	0.443		0.438	0.438	0.438			
B	1.745	1.755		1.750	1.750	1.750			
C	3.495	3.505		3.500	3.500	3.500			
D	1.745	1.755		1.750	1.750	1.750			
E	7.990	8.010		7.999	7.999	7.999			
F	0.490	0.510		0.500	0.500	0.500			
G	0.257	0.262		0.258	0.258	0.258			
H	0.375	0.380		0.376	0.376	0.376			
I	0.490	0.510		0.502	0.503	0.502			
J	1.174	1.184		1.179	1.179	1.179			
K	0.558	0.578		0.567	0.567	0.567			
L	1.174	1.184		1.179	1.179	1.179			
M	1.490	1.500		1.495	1.495	1.495			
N	2.495	2.505		2.500	2.500	2.500			
O	3.869	3.879		3.874	3.874	3.874			
P	0.115	0.135		0.135	0.135	0.135			
Q	0.115	0.135		0.123	0.123	0.123			
R	0.240	0.260		0.249	0.248	0.248			
S	0.115	0.135		0.128	0.128	0.127			
T	0.178	0.198		0.188	0.188	0.188			
U	2.940	2.980		2.930	2.930	2.930			
V	0.230	0.250		0.243	0.243	0.243			
W	0.115	0.135		0.120	0.119	0.120			
X	0.308	0.313		0.310	0.291	0.311			
Y	0.760	0.765		0.760	0.760	0.760			
Z	0.352	0.372		0.363	0.363	0.363			
AA	0.470	0.530		0.500	0.500	0.500			
AB	0.615	0.635		0.627	0.627	0.627			
AC	0.053	0.073		0.063	0.063	0.063			
AD	0.240	0.260		0.251	0.251	0.251			
AE	1.375	1.395		1.385	1.385	1.385			
AF	0.115	0.135		0.135	0.135	0.135			
AG	0.240	0.280		0.245	0.245	0.245			
AH	0.240	0.260		0.249	0.250	0.249			
AI	2.000	2.020		2.000	2.000	2.000			
AJ	0.023	0.043		0.032	0.032	0.032			
Accept/Reject							DAS		

Measured by: <u>B. e</u>	Audited by: <u>9-30</u>
Date: <u>16/08/13</u>	Date: <u>16/08/22</u>

Rev	Date	Change	Revised by	Approved
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	